



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4032-041

Job Sheet 195011



Part No: D4032-041

Job Qty: 1 pcs

Part Name: Short Basket Assembly (350)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/13/19

Job Tracking No:

Due Date: 6/20/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV E SHEETS 1,3,4 IPP RevA: new issue DD 09.12.02 verified by:EC IPP Rev:B as per PA3 DD 10.03.10 verified by:EC IPP Rev:C as per RevA DD 10.03.23 verified by:EC IPP Rev:D as per dwg revC DD 10.04.20 verified by:EC IPP Rev:E as per dwg revD DD 10.08.18 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Packaging 1 - Pick Kit	1 pcs		6/20/19	0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		

BEB 19-07-09

Plex 5/13/19 10:47 AM Dart.lajeunesse.marie

110 Handfinish - 4-1-Assembly-B4B	1 pcs	6/20/19	0.00 1.16	Packaging 1 - 31	
				Packaging 1 - 32	
				Packaging 1 - 33	
				Packaging 1 - 34	
				Packaging 1 - 35	
				Packaging 1 - 36	
				Handfinish - 4 - 1 - B4B	
				Handfinish - 4 - 10 - B4B	BE819-07-09
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
120 QC 5	1 pcs	6/20/19	0.00 0.00	Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
130 Packaging 3-1 - Stock - B4B	1 pcs	6/20/19	0.00 0.00	QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	

				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	DAS
				Packaging 3 - 21 - B4B	75
				Packaging 3 - 22 - B4B	9-89
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	JUL 31 2019
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	1	6/20/19	0.00 0.00	QC 21 - SA - 21	
	pcs			QC 21 - SA - 70	
				QC 21 - SA - 53	AUG 01 2019

Part Op 100 - (Pick Kit)

Descriptions: 110 - (Assemble as per dwg) ****Mask label plate to size of D4086 label, use scotchbrite red pad to lightly sand area for label, apply label ****

120 - (QC5- Inspect part completeness to step on W/O)

130 - (Identify as per dwg & Stock Location: _____)

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-15A	Bolt	4 Ea (4 ea)	100-Packaging 1 - Pick Kit	5161920
AN3-16A	Bolt	2 Ea (2 ea)	100-Packaging 1 - Pick Kit	5157471-2.
AN310-4	Nut	3 Ea (3 ea)	100-Packaging 1 - Pick Kit	5156896.
AN310C4	Nut	2 Ea (2 ea)	100-Packaging 1 - Pick Kit	5156966.
AN4-12	Bolt	3 Ea (3 ea)	100-Packaging 1 - Pick Kit	5181041
AN5-17A	Bolt	4 Ea (4 ea)	100-Packaging 1 - Pick Kit	2x 5156671-5/2.5 149141
D2530	Handle Weldment	1 pcs (1 ea)	100-Packaging 1 - Pick Kit	5186637.
D2535	Spring	2 pcs (2 ea)	100-Packaging 1 - Pick Kit	5154034.
D2537	Bushing	2 pcs (2 ea)	100-Packaging 1 - Pick Kit	5123161
D3917-3	Washer	6 pcs (6 ea)	100-Packaging 1 - Pick Kit	5176362.
D3953-17	Gas Spring Spacer	2 pcs (2 ea)	100-Packaging 1 - Pick Kit	1x 5179592/5196145
D3953-19	Gas Spring Bracket	1 pcs (1 ea)	100-Packaging 1 - Pick Kit	5184917.
D3953-21	Gas Spring Bracket	1 pcs (1 ea)	100-Packaging 1 - Pick Kit	5173004.
D3953-3	Gas Spring Stud, Lid	2 pcs (2 ea)	100-Packaging 1 - Pick Kit	5163194.
D3953-7	Spring Spacer	2 pcs (2 ea)	100-Packaging 1 - Pick Kit	5188826.
D3953-9	Gas Spring Washer	2 pcs (2 ea)	100-Packaging 1 - Pick Kit	5173358.
D3969-3	Spring (Basket Lid)	1 pcs (1 ea)	100-Packaging 1 - Pick Kit	5163140
D4017-041	Short Basket Base Assembly (350)	1 pcs (1 ea)	100-Packaging 1 - Pick Kit	5195913.
D4018-041	AS350 Short Basket Lid Assembly	1 pcs (1 ea)	100-Packaging 1 - Pick Kit	5195945
MS21042L3	Nut	6 Ea (6 ea)	100-Packaging 1 - Pick Kit	5157462-1
MS21042L5	Nut	4 Ea (4 ea)	100-Packaging 1 - Pick Kit	5176461
MS24665-151	Cotter Pin	3 Ea (3 ea)	100-Packaging 1 - Pick Kit	5144955
MS24665-300	Cotter Pin	2 Ea (2 ea)	100-Packaging 1 - Pick Kit	5157264.
NAS1149C0432R	Washer	2 Ea (2 ea)	100-Packaging 1 - Pick Kit	5103990.
NAS1149F0332P	Washer	8 Ea (8 ea)	100-Packaging 1 - Pick Kit	5155976.
NAS1149F0432P	Washer	6 Ea (6 ea)	100-Packaging 1 - Pick Kit	5155666
NAS1149F0563P	Washer	4 Ea (4 ea)	100-Packaging 1 - Pick Kit	1x 5098031/3x 518494.

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Packaging 1 - Pick Kit	AN3-15A	4	110	0
	AN3-16A	2	186	0
	AN310-4	3	114	0
	AN310C4	2	70	0
	AN4-12	3	58	0
	AN5-17A	4	104	0
	D2530	1	11	0
	D2535	2	228	0
	D2537	2	112	0
	D3917-3	6	108	0
	D3953-17	2	31	0
	D3953-19	1	4	0
	D3953-21	1	48	0
	D3953-3	2	38	0
	D3953-7	2	44	0
	D3953-9	2	36	0
	D3969-3	1	54	0
	D4017-041	1	1	0
	D4018-041	1	1	0
	MS21042L3	6	2,855	0
	MS21042L5	4	741	0
	MS24665-151	3	399	0
	MS24665-300	2	568	0
	NAS1149C0432R	2	1,288	0
	NAS1149F0332P	8	4,629	0
	NAS1149F0432P	6	1,545	0
	NAS1149F0563P	4	243	0
Part Specifications				
Specifications could not be found.				

Plex 5/13/19 10:47 AM Dart.lajeunesse.marie

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ ☐ Scrap ☐ ☐ ☐ Use-as-is ☐ ☐ ☐				DEPARTMENT/PROCESS Skid-tube ☐ ☐ ☐ ☐ ☐ Machining ☐ ☐ ☐ ☐ ☐ Large Fab ☐ ☐ ☐ ☐ ☐				Cross tube ☐ ☐ ☐ ☐ ☐ Small Fab ☐ ☐ ☐ ☐ ☐ Finishing ☐ ☐ ☐ ☐ ☐				Eng. (Non-AW) ☐ ☐ ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐ ☐ ☐				Engineering ☐ ☐ ☐ ☐ ☐ Water Jet ☐ ☐ ☐ ☐ ☐ Supplier ☐ ☐ ☐ ☐ ☐ Quality ☐ ☐ ☐ ☐ ☐				MRB (QS1042)																	
Date : _____		Sequence #: _____		QTY Affected : _____		Disposition																																	
Description Work Order Deviation										Completed By																													
										Lead hand / Supervisor																													
										QC / QA Coordinator																													
Root Cause Operator ☐ ☐ ☐ ☐ ☐ Manufacturing Process ☐ ☐ ☐ ☐ ☐ Equip/Tooling ☐ ☐ ☐ ☐ ☐ Handling/Preservation ☐ ☐ ☐ ☐ ☐ Material ☐ ☐ ☐ ☐ ☐ Product Improvement ☐ ☐ ☐ ☐ ☐ Process Improvement ☐ ☐ ☐ ☐ ☐ Human Factors ☐ ☐ ☐ ☐ ☐										FAULT CATEGORY Contamination ☐ ☐ ☐ ☐ ☐ Misaligned/off center ☐ ☐ ☐ ☐ ☐ BOM/Route ☐ ☐ ☐ ☐ ☐ Broken/Damage/Defect ☐ ☐ ☐ ☐ ☐ Incomplete/Unclear Instructions ☐ ☐ ☐ ☐ ☐ Drill Holes ☐ ☐ ☐ ☐ ☐ Fit/Function ☐ ☐ ☐ ☐ ☐										Power Loss/Surge ☐ ☐ ☐ ☐ ☐ Folio/Program ☐ ☐ ☐ ☐ ☐ Grain Direction ☐ ☐ ☐ ☐ ☐ Weld ☐ ☐ ☐ ☐ ☐ Wrong Stock Pulled ☐ ☐ ☐ ☐ ☐ Out of Sequence ☐ ☐ ☐ ☐ ☐ Off-set/Set-up ☐ ☐ ☐ ☐ ☐										Positioned Wrong ☐ ☐ ☐ ☐ ☐ Outside Tolerance ☐ ☐ ☐ ☐ ☐ Drawing ☐ ☐ ☐ ☐ ☐ Finish ☐ ☐ ☐ ☐ ☐ Part Lost/Missing ☐ ☐ ☐ ☐ ☐ Misread ☐ ☐ ☐ ☐ ☐									
Other/Details:																																							